

NAVAL

w/Jef

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBBP1425-103-03
Job Sheet 181446



JS
8-17
HJD

Part No: RBBP1425-103-03

Job Qty: 20 ea

DAS
21
2.89

Part Name: Keeper



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Part Created: 7/26/18

Job Tracking No:

Due Date: 8/20/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBBP1425-101 Rev D IPP Rev A 18.03.13 New issue DP Verify DD/DWG RBBP1425-101 Rev D IPP
Rev B 18.04.04 DWG update DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea	8/20/18	8/20/18	0.00	0.00	Start Up Machining-3		DL 18/08/21
100	Waterjet	20 pcs	8/20/18	8/20/18	0.00	2.00	Waterjet 2 OMAX		DL 18/08/21
110	Mori Seiki	20 pcs	8/20/18	8/20/18	0.00	10.00	MORI SL2500Y		DL 18-10-17
120	QC	20 pcs	8/20/18	8/20/18	0.00	0.00	QC2 Machining-4		DL
130	Mori Seiki	20 pcs	8/20/18	8/20/18	0.00	5.00	MORI NV5000-1		DL 18/10/24
140	QC	20 pcs	8/20/18	8/20/18	0.00	0.00	QC2 Machining-4		DL 18/10/24
150	QC	20 pcs	8/20/18	8/20/18	0.00	0.00	QC8 Machining-4		DL 18-10-25
180	Outsource	20 pcs	8/20/18	8/20/18			GRO002-VC	10	DL 18-10-25
200	Packaging	20 pcs	8/20/18	8/20/18	0.00	0.00	Packaging2		DL NOV 07 2018
210	QC	20 pcs	8/20/18	8/20/18	0.00	0.00	QC6		DL 38
215	Packaging	20 pcs	8/20/18	8/20/18	0.00	0.00	Packaging3		DL 9-89
220	QC21-SA	20 Ea	8/20/18	8/20/18	0.00	0.00	QC21		DL 21

Part Op 100 - 1-Cut blanks (RED BARN FOLDER) ***Note***makes four pieces***
 Descriptions: 110 - 1-Machine as per folio FC025 FOLIO REV: AA DWG REV: D 2-Deburr
 130 - 1-Machine as per folio FC025 FOLIO REV: DWG REV: ***Note***makes four
 pieces*** 2-Deburr 3-Machine engrave as per note 6
 180 - -Issue P/O to Groupe Altech; PO 041464 -Black oxide finish, MIL-C-13924C Class 1 -Certificate of
 Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140-S-0.500X10.000	AlSI 4140 Steel Sheet/Plate	12 ft (.6 ea)	90-Start up Operation	5070827

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-4140-S-0.500X10.000	12	15	0

Part Specifications

Specifications could not be found.

Plex 8/17/18 1:37 PM dart.logan.david



Container No: S104117



Part: RBBP1425-103-03

Job No: 181446

Serial No/Batch: S104117

Revision: D

Inspector:

Exp Date:

Instructions:

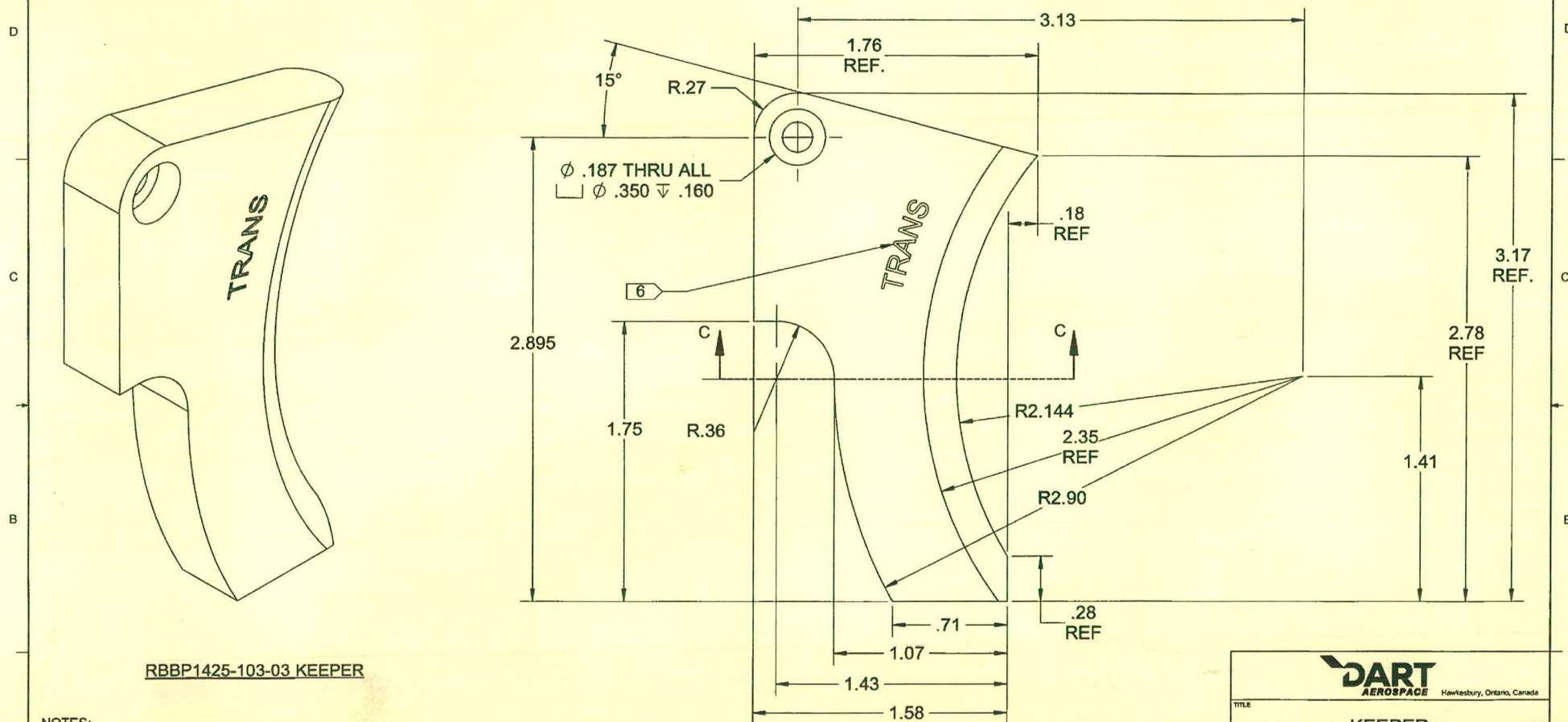
Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 08/21/18

8105 S O VOM

8105 S O VOM

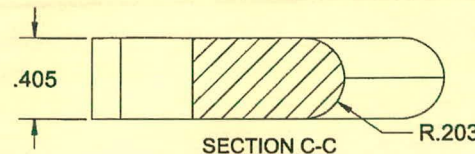
REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
C	TEMPLATE UPDATED, MATERIAL 4140/4142 CHANGED FOR 17-4 PH / H900, FINISH REMOVED, VIEWS CHANGED FOR CLARITY, NOTE 7 ADDED	17-647	18.1.23	VM	ML



RBBP1425-103-03 KEEPER

NOTES:

- 1) MATERIAL: 17-4 PH SS / H900 OR 4140/4142 (Rc 28-32)
- 2) FINISH: IF MANUFACTURED FROM 17-4PH-H900: N/A
IF MANUFACTURED FROM 4140/4142 : BLACK OXIDE PER MIL-C-13924 CLASS 1/2/4 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 3) HEAT TREAT: N/A
- 4) SPEC: N/A
- 5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
- 6) IDENTIFICATION: MACHINE ENGRAVE AS SHOWN AND FILL WITH BLACK INK, 0.010" DEPTH
- 7) REFER TO CAD MODEL FOR ALL NON DIMENSIONED FEATURES



DART AEROSPACE Hawkesbury, Ontario, Canada	
TITLE KEEPER	
PART NO. RBBP1425-103-03	REV D
TOOL NO. RBBP1425-103	
INITIALS AND DATE	
DESIGNED BY: VM 1/23/2018	TOLERANCES: UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES INTERPRET PER ASME Y14.5M-2009 DIMENSIONS APPLY AFTER FINISHING
DRAWN BY: ML 03/20/2018	JOXX ± .005
CHECKED BY: ML 03/20/2018	XX ± .01
MFG REVIEW BY: DP 03/20/2018	X ± .1
APPROVED BY: ML 03/26/2018	FRACTIONS ± 1/8
	ANGLES ± .5°
	SURFACE ROUGHNESS
	SCALE: NTS
	SHEET 5 OF 12
COPYRIGHT © 2017 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE**DART**
AEROSPACE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>					Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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					Lead hand / Supervisor Approval Verification																																																																	
					QC / QA Coordinator Approval																																																																	
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041464**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO041464
PO Date: 10/25/18
Due Date: 10/31/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Phone:

Via: Ground
Pynt Terms: Net 60
Freight Terms:
Special Comments:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	181446	RBBP1425-103-03	Keeper -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	10/31/18	24 pcs	0 pcs	24 pcs	\$5.00/pcs	\$120.00
Grand Total:											\$120.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

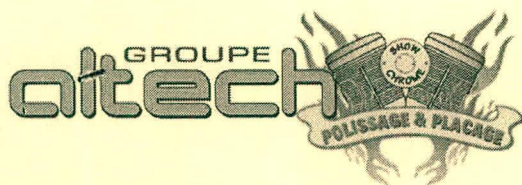
A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 10/25/18 1:05 PM dart.tsimiklis.chrisoula

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Certificat de Conformité / Certificate of Compliance

(013877-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaitech.com

Bon de Livraison / Packing Slip

013877 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
01-Nov-2018		Aman		041464 ✓				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBBP1425-103-03 ✓ Rev.	RBBP1425-103-03 01-OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS1	OXIDE-BLACK CH	24 ✓	24	0	0	0

 DAS
 38
 9-89

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness
Inspecteur Qualité
Quality Inspector
Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.

